



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SKID
D205-634-141
Job Sheet 166828



Part No: D205-634-141

Job Qty: 1 ea

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/17/17

RH

Job Tracking No:

Due Date: 11/7/17

Created By: Mario Poulin

Type: *SE-3*

Description:

Customer: Kestrel Aviation Pty Ltd (CKEST03)

325 Aerodrome Road Mangalore, Victoria, 3663 Australia

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/6/17	0.00	0.00	Start Up Skidtubes	
110	Skidtubes	1 pcs		11/6/17	0.00	0.65	Skidtubes <i>M66</i>	
120	CNC Bend Skidtubes	1 pcs		11/6/17	0.52	0.65	CNC Bend Skidtube <i>M66</i>	
130	Skidtubes	1 pcs		11/6/17	0.00	0.65	Skidtubes <i>J.Y.</i>	
140	QC	1 pcs		11/6/17	0.00	0.00	QC5 <i>BC</i>	
150	Skidtubes	1 pcs		11/6/17	0.00	0.65	Skidtubes <i>BC</i>	
160	QC	1 pcs		11/6/17	0.00	0.00	QC10 <i>38</i>	
170	QC	1 pcs		11/6/17	0.00	0.00	QC5 <i>38</i>	
180	HandFinish	1 pcs		11/6/17	0.00	0.04	HandFinish2 <i>18-02-06</i>	
190	Powdercoat	1 pcs		11/6/17	0.00	0.25	Powdercoat1 <i>BR 18-02-06</i>	
200	QC	1 pcs		11/6/17	0.00	0.00	QC3 <i>BR 18-02-06</i>	
210	HandFinish	1 pcs		11/7/17	0.00	0.83	HandFinish4 <i>BR 18-02-07</i>	
220	QC	1 pcs		11/7/17	0.00	0.00	QC5 <i>38</i>	
225	DC	1 pcs		11/7/17	0.00	0.00	DC <i>38</i>	
230	Packaging	1 pcs		11/7/17	0.00	0.00	Packaging3 <i>38</i>	
240	QC21-FG	1 Ea		11/7/17	0.00	0.00	QC21 <i>38</i>	

Part Op 110 - 1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL 3.630" HOLES
Descriptions: USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY)

120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size.

150 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod *M138673*
2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR

180 - And realodine tube as per QSI 005

190 - START TIME: *1:00* *Q.T. 300° FINISH: 1:50.*

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates *18/04*
2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# *M138711*

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004

230 - Identify and pack for shipping as per PPPD205-634-141 Location : FG084

DART
AEROSPACE
S037427

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



**Replacement Skidtube with Run – on Landing Wearplates Fits
LH or RH**

PART NO: D205 – 634 – 141

Original Serial #: S037427

Revision:

Operation: Start up Operation 01/31/18

Change No: CHG004

Job No: 166828

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2580-1 <i>5014926</i>	<i>①</i>	8	0	0
150-Skidtubes	D2576-3 <i>F151399</i>	1	24	0	0
	D4202-1 <i>5030798</i> — <i>②</i>	<i>24</i>	362	0	0
210-HandFinish	AN3-5A <i>5013733</i>	2	153	0	0
	AN4-45A <i>5038734</i>	8	42	0	0
	D2570 <i>5030004</i>	16	91	0	0
	D2594-1 <i>5025442</i>	8	374	0	0
	D2594-3 <i>F159710</i>	8	440	0	0
	D2855 <i>F151613</i>	1	92	0	0
	<i>-</i> D4406-041 <i>5018138</i>	1	2	0	0
	D4406-043 <i>5038772</i>	1	0	0	0
	MS21042-4 <i>5038763</i>	8	0	0	0
	NAS1149D0332J <i>5020606</i>	2	1,532	0	0
Part Specifications					
Specifications could not be found.					

Plex 10/17/17 2:01 PM dart.poulin.mario

000604

ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2555	AFT CAP
28	1	1			D3564-5	WEARSHOE
29	1	1			D3564-9	WEARSHOE
30	1	1			D3564-11	WEARSHOE
31	1	1			D3564-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN980C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN980J10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- MATERIAL: N/A
- FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.5) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: NONE
- WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-048 = 32.0 lbs
- WELDING PER DART QSI 004.
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- USE DART DRILL TEMPLATE DT8217 & DT8637 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2555 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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NO. 166828
OCT 17 2017

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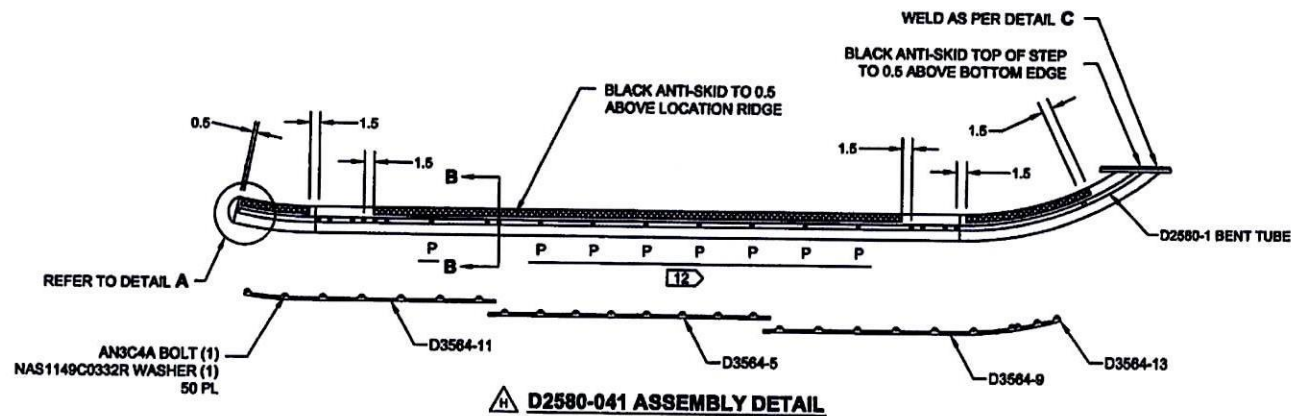
2017 JUL 05
BENT-518

H	SHEET: PL DELETE D3566-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DS1 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8637 WAS TD2577-205 (ZN C4-1)	RF	11.08.21
D	CHANGE TO 55 WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9153	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	06.08.28
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
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DE APPR.	<i>[Signature]</i>		
DATE	17.06.09		

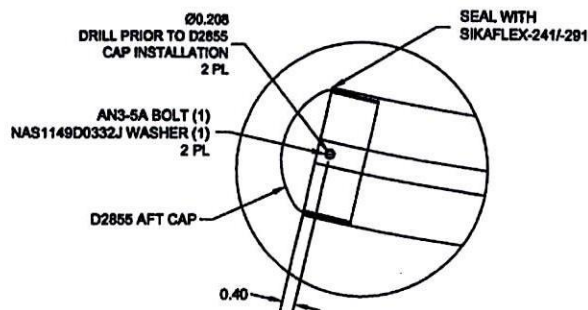
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2580
TITLE 205 SKIDTUBE ASSEMBLY
REV. H
SHEET 1 OF 9
SCALE NTS

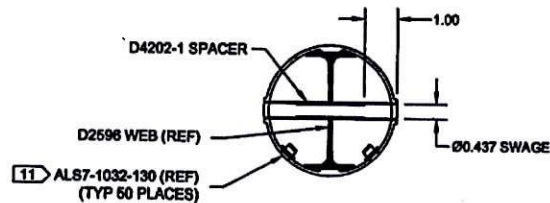
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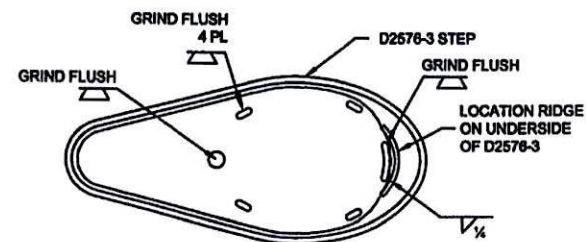


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

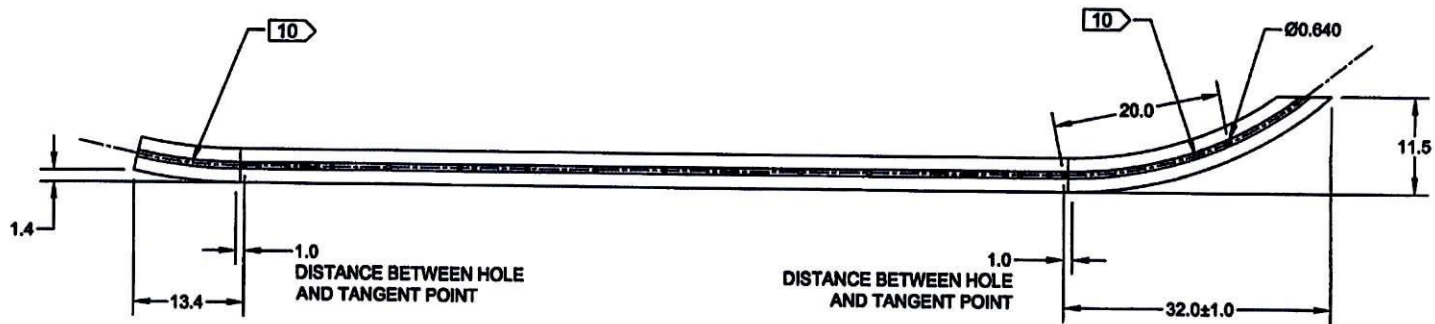
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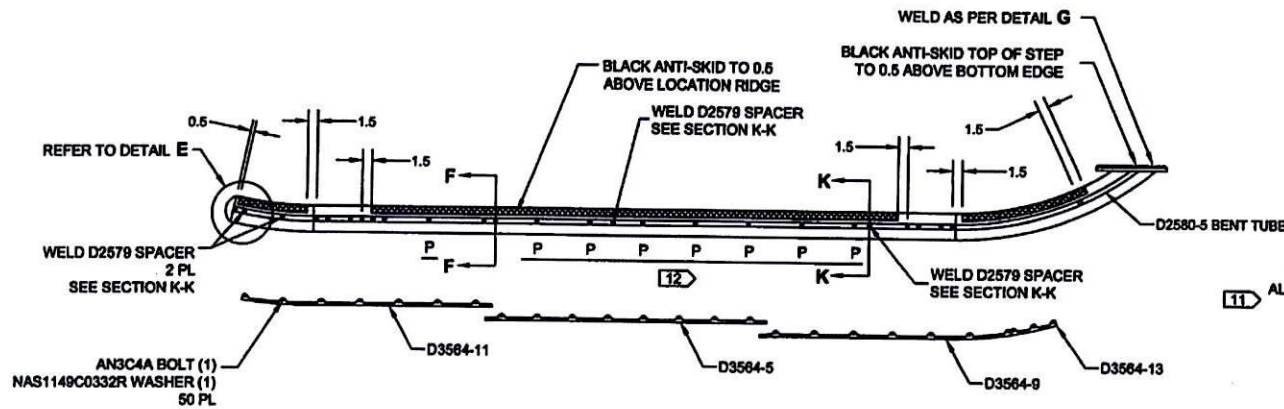
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 9
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DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

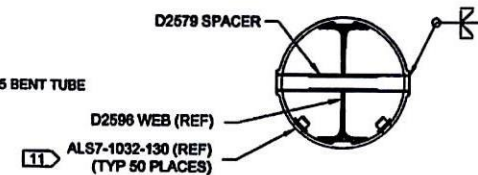
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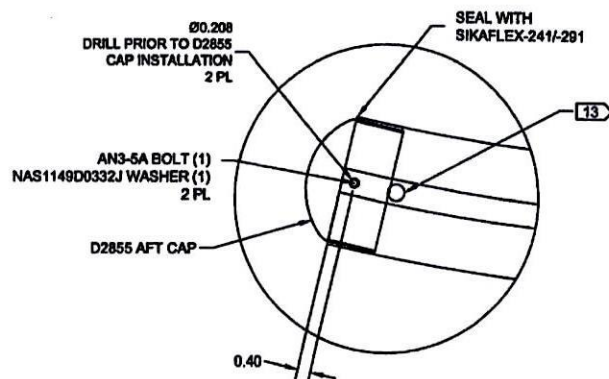
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
SCALE 5X**

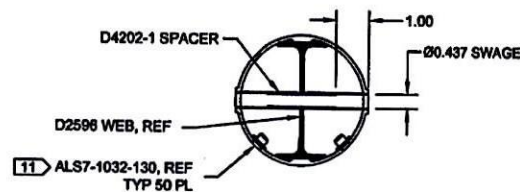


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT CBORE

**DETAIL E
SCALE 5X**

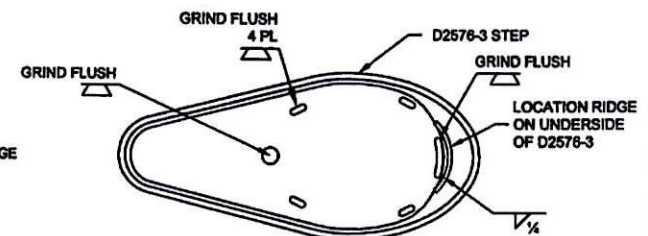


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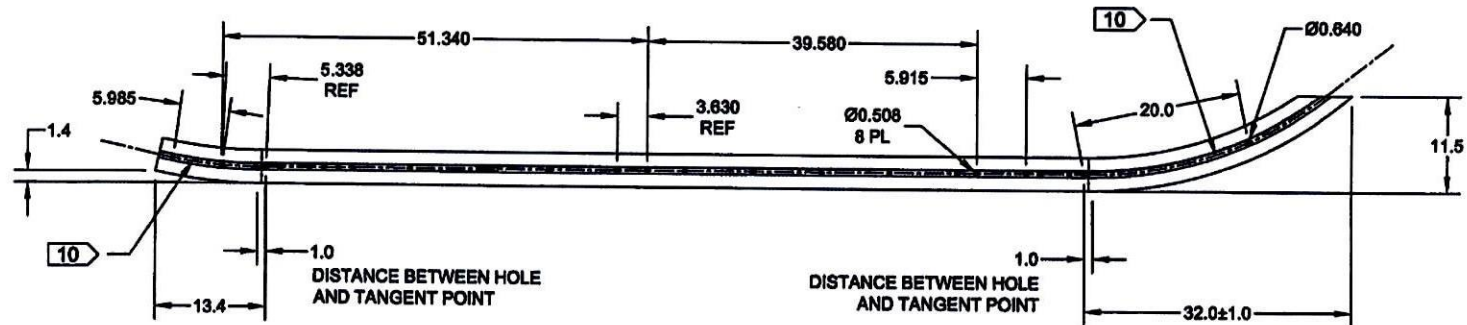
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



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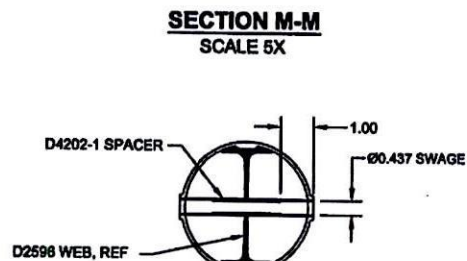
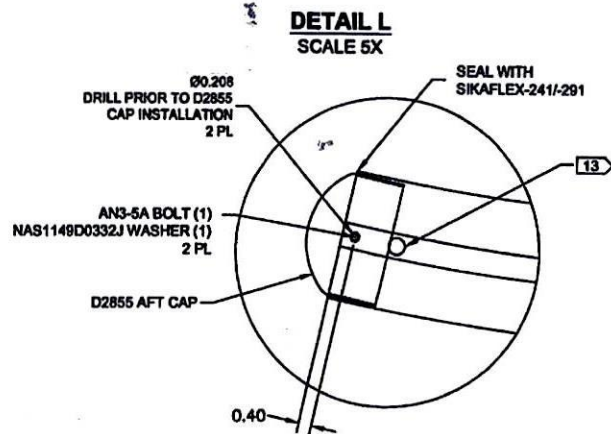
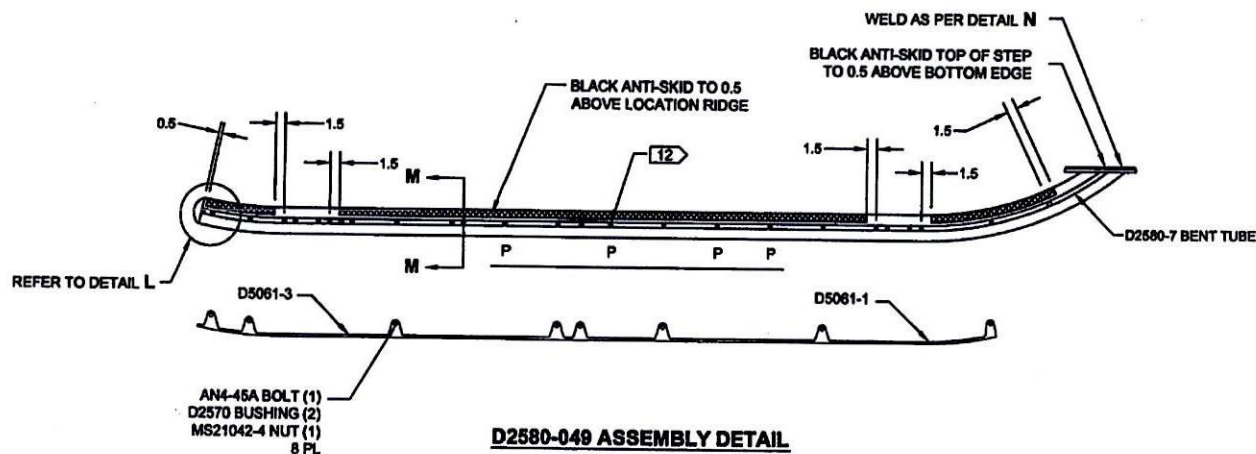


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

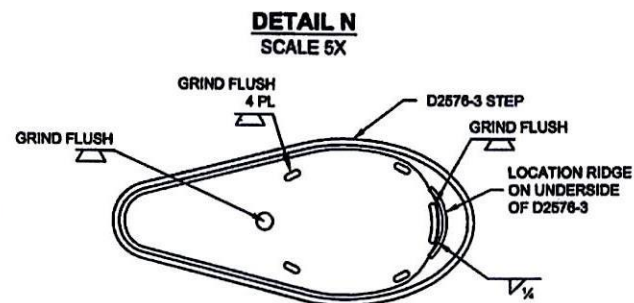
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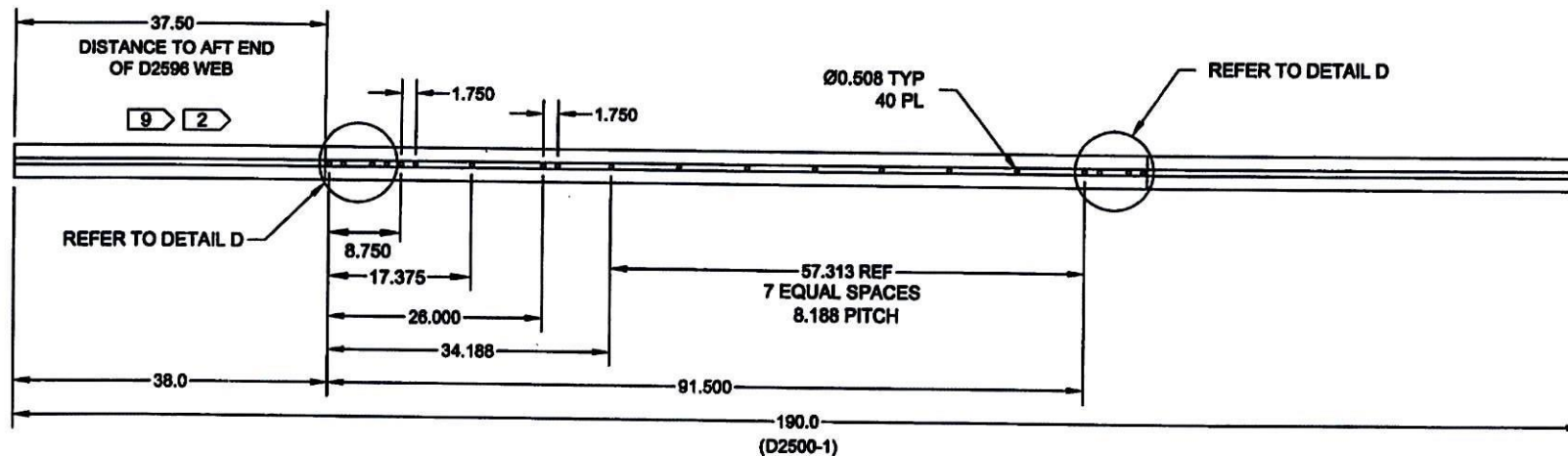
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



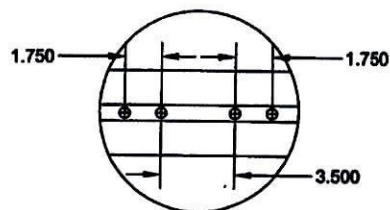
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D2580-101 TUBE



DETAIL D
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